

# इंटरनेट

# मानक

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Whereas the Parliament of India has set out to provide a practical regime of right to information for citizens to secure access to information under the control of public authorities, in order to promote transparency and accountability in the working of every public authority, and whereas the attached publication of the Bureau of Indian Standards is of particular interest to the public, particularly disadvantaged communities and those engaged in the pursuit of education and knowledge, the attached public safety standard is made available to promote the timely dissemination of this information in an accurate manner to the public.

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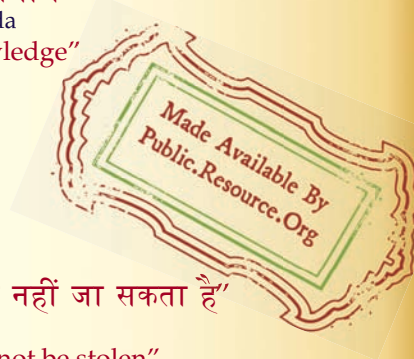
IS 15582 (2005): Hexagon Flange Bolts - Small Series [PGD  
31: Bolts, Nuts and Fasteners Accessories]



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“Knowledge is such a treasure which cannot be stolen”



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भारतीय मानक  
षटकोणी फ्लैज बोल्ट — लघु श्रृंखला

*Indian Standard*  
HEXAGON FLANGE BOLTS — SMALL SERIES

ICS 21.060.10

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**BUREAU OF INDIAN STANDARDS**  
MANAK BHAVAN, 9 BAHADUR SHAH ZAFAR MARG  
NEW DELHI 110002

## NATIONAL FOREWORD

This Indian Standard which is identical with ISO 4162 : 1990 'Hexagon flange bolts — Small series' issued by the International Organization for Standardization ( ISO ) was adopted by the Bureau of Indian Standards on the recommendations of the Bolts, Nuts and Fasteners Accessories Sectional Committee and approval of the Medical Instruments, General and Production Engineering Division Council.

The text of ISO Standard has been approved as suitable for publication as an Indian Standard without deviations. Certain terminology and conventions are, however, not identical to those used in Indian Standards. Attention is drawn especially to the following:

- a) Wherever the words 'International Standard' appear, referring to this standard, they should be read as 'Indian Standard'.
- b) Comma ( , ) has been used as a decimal marker while in Indian Standards, the current practice is to use a point ( . ) as the decimal marker.

In this adopted standard, reference appears to certain International Standards for which Indian Standards also exist. The corresponding Indian Standards, which are to be substituted in their places are listed below along with their degree of equivalence for the editions indicated:

<i>International Standard</i>	<i>Corresponding Indian Standard</i>	<i>Degree of Equivalence</i>
ISO 225 : 1983 Fasteners — Bolts, screws, studs and nuts — Symbols and designation of dimensions	IS 8536 : 1987 Fasteners — Bolts, screws, studs and nuts — Symbols and designation of dimensions ( <i>first revision</i> )	Identical
ISO 261 : 1973 <sup>1)</sup> ISO general purpose metric screw threads — General plan	IS 4218 ( Part 2 ) : 2001 ISO general purpose metric screw threads: Part 2 General plan ( <i>second revision</i> )	Technically equivalent
ISO 888 : 1976 Bolts, screws and studs — Nominal lengths and thread lengths for general purpose bolts	IS 4206 : 1987 Dimensions for nominal lengths and thread lengths for bolts, screws and studs ( <i>first revision</i> )	Identical
ISO 898-1 : 1988 <sup>2)</sup> Mechanical properties of fasteners — Part 1: Bolts, screws and studs	IS 1367 ( Part 3 ) : 2002 Technical supply conditions for threaded steel fasteners: Part 3 Mechanical properties of fasteners made of carbon steel and alloy steel — Bolts, screws and studs ( <i>fourth revision</i> )	Technically equivalent
ISO 965-2 : 1980 <sup>1)</sup> ISO general purpose metric screw threads — Tolerances — Part 2 : Limits of sizes for general purpose bolt and nut threads — Medium quality	IS 14962 ( Part 2 ) : 2001 ISO general purpose metric screw threads — Tolerances: Part 2 Limits of sizes for general purpose external and internal screw threads — Medium quality	do

<sup>1)</sup> Since revised in 1998.

<sup>2)</sup> Since revised in 1999.

<i>International Standard</i>	<i>Corresponding Indian Standard</i>	<i>Degree of Equivalence</i>
ISO 3269 : 1988 <sup>1)</sup> Fasteners — Acceptance inspection	IS 1367 ( Part 17 ) : 2005 Technical supply conditions for threaded steel fasteners: Part 17 Inspection, sampling and acceptance procedure ( <i>fourth revision</i> )	Technically equivalent
ISO 3506 : 1979 <sup>2)</sup> Corrosion resistant stainless steel fasteners — Specifications	IS 1367 ( Part 14/Sec 1 ) : 2002 Technical supply conditions for threaded steel fasteners: Part 14 Mechanical properties of corrosion resistant stainless-steel fasteners, Section 1 Bolts, screws and studs ( <i>third revision</i> )	do
	IS 1367 ( Part 14/Sec 2 ) : 2002 Technical supply conditions for threaded steel fasteners: Part 14 Mechanical properties of corrosion resistant stainless-steel fasteners, Section 2 Nuts ( <i>third revision</i> )	do
	IS 1367 ( Part 14/Sec 3 ) : 2002 Technical supply conditions for threaded steel fasteners: Part 14 Mechanical properties of corrosion resistant stainless-steel fasteners, Section 3 Set screws and similar fasteners not under tensile stress ( <i>third revision</i> )	do
ISO 4042 : 1989 <sup>3)</sup> Threaded components — Electroplated coatings	IS 1367 ( Part 11 ) : 2002 Technical supply conditions for threaded steel fasteners: Part 11 Electroplated coatings ( <i>third revision</i> )	do
ISO 4753 : 1983 <sup>3)</sup> Fasteners — Ends of parts with external metric ISO thread	IS 1368 : 2003 Fasteners — Ends of parts with external ISO metric thread ( <i>fourth revision</i> )	do
ISO 4759-1 : 1978 <sup>1)</sup> Tolerances for fasteners — Part 1 : Bolts, screws and nuts with thread diameters $\geq 1.6$ and $\leq 150$ mm and product grades A, B and C	IS 1367 ( Part 2 ) : 2002 Technical supply conditions for threaded steel fasteners: Part 2 Tolerance for fasteners — Bolts, screws, studs and nuts — Product grades A, B and C ( <i>third revision</i> )	do
ISO 6157-1 : 1988 Fasteners — Surface discontinuities — Part 1: Bolts, screws and studs for general requirements	IS 1367 ( Part 9/Sec 1 ) : 1993 Technical supply conditions for threaded steel fasteners: Part 9 Surface discontinuities, Section 1 Bolts, screws and studs for general applications ( <i>third revision</i> )	Identical

<sup>1)</sup> Since revised in 2000.

<sup>2)</sup> Since revised in 1997 in three parts.

<sup>3)</sup> Since revised in 1999.

<i>International Standard</i>	<i>Corresponding Indian Standard</i>	<i>Degree of Equivalence</i>
ISO 6157-3 : 1988 Fasteners — Surface discontinuities — Part 3 : Bolts, screws and studs for special requirements	IS 1367 ( Part 9/Sec 2 ) : 1993 Technical supply conditions for threaded steel fasteners: Part 9 Surface discontinuities, Section 2 Bolts, screws and studs for special applications ( <i>third revision</i> )	Identical
ISO 8992 : 1986 Fasteners — General requirements for bolts, screws, studs and nuts	IS 1367 ( Part 1 ) : 2002 Technical supply conditions for threaded steel fasteners: Part 1 General requirements for bolts, screws and studs ( <i>third revision</i> )	do

As decided by the Committee additional requirements of packaging and BIS Certification Marking are given in National Annex A. These additional requirements are part of this standard.

For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test or analysis, shall be rounded off in accordance with IS 2 : 1960 'Rules for rounding off numerical values ( *revised* )'. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

*Indian Standard*  
**HEXAGON FLANGE BOLTS — SMALL SERIES**

## **1 Scope**

This International Standard gives specifications for hexagon flange bolts, small series, with threads from M5 up to and including M16 and property classes 8.8 to 10.9 and A2-70.

If, in special cases, specifications other than those listed in this International Standard are required, they should be selected from existing International Standards, for example ISO 261, ISO 888, ISO 898-1, ISO 965-2, ISO 3506.

## **2 Normative references**

The following standards contain provisions which, through reference in this text, constitute provisions of this International Standard. At the time of publication, the editions indicated

were valid. All standards are subject to revision, and parties to agreements based on this International Standard are encouraged to investigate the possibility of applying the most recent editions of the standards indicated below. Members of IEC and ISO maintain registers of currently valid International Standards.

ISO 225 : 1983, *Fasteners — Bolts, screws, studs and nuts — Symbols and designations of dimensions.*

ISO 261 : 1973, *ISO general purpose metric screw threads — General plan.*

ISO 888 : 1976, *Bolts, screw and studs — Nominal lengths, and thread lengths for general purpose bolts.*

ISO 898-1 : 1988, *Mechanical properties of fasteners — Part 1: Bolts, screws and studs.*



ISO 965-2 : 1980, *ISO general purpose metric screw threads — Tolerances — Part 2: Limits of sizes for general purpose bolt and nut threads — Medium quality.*

ISO 3269 : 1988, *Fasteners — Acceptance inspection.*

ISO 3506 : 1979, *Corrosion-resistant stainless steel fasteners — Specifications.*

ISO 4042 : 1989, *Threaded components — Electroplated coatings.*

ISO 4753 : 1983, *Fasteners — Ends of parts with external metric ISO thread.*

ISO 4759-1 : 1978, *Tolerances for fasteners — Part 1: Bolts, screws and nuts with thread diameters  $> 1,6$  and  $< 150$  mm and product grades A, B and C.*

ISO 6157-1 : 1988, *Fasteners — Surface discontinuities — Part 1: Bolts, screws and studs for general requirements.*

ISO 6157-3 : 1988, *Fasteners — Surface discontinuities — Part 3: Bolts, screws and studs for special requirements.*

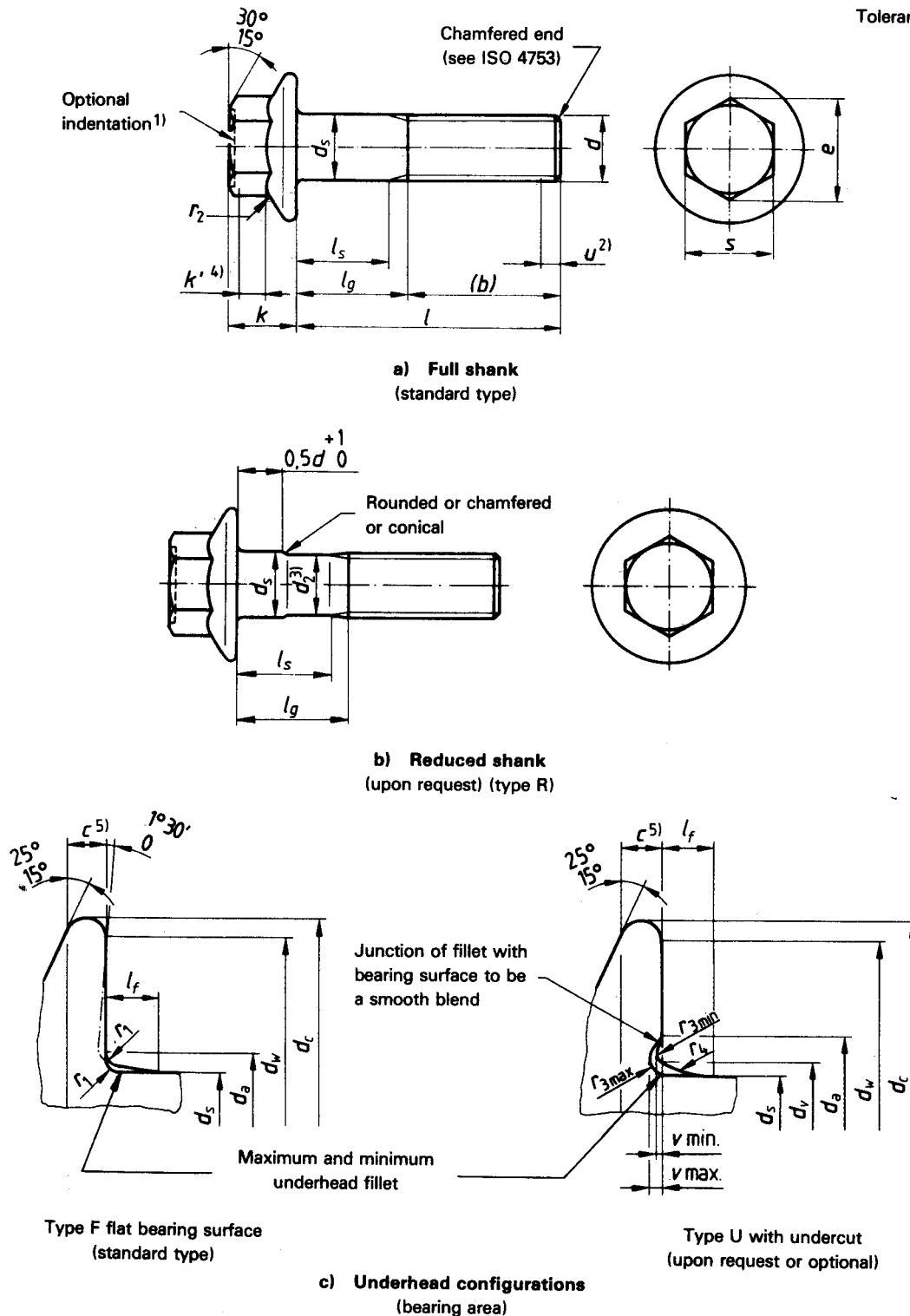
ISO 8992 : 1986, *Fasteners — General requirements for bolts, screws, studs and nuts.*

### 3 Dimensions

See figure 1 and table 1.

NOTE — Symbols and designations of dimensions are specified in ISO 225.

Tolerances in millimetres



1) The top of the head shall be either full form or indented at the manufacturer's option and shall be either chamfered or rounded. The minimum diameter of the chamfer circle or start of rounding shall be the maximum width across flats minus 15 %. If the top of the head is indented, the periphery may be rounded.

2) Incomplete thread  $u < 2 P$ .

3)  $d_2$  is approximately equal to the pitch diameter (rolling diameter).

4)  $k'$  is the minimum wrenching height; see the note to table 1.

5)  $c$  is measured at  $d_{w \min}$ .

Figure 1

Table 1

Dimensions in millimetres

Thread (d)		M5	M6	M8	M10	M12	(M14) <sup>1)</sup>	M16
$p^{2)}$		0,8	1	1,25	1,5	1,75	2	2
$b$ ref.	3)	16	18	22	26	30	34	38
	4)	—	—	28	32	36	40	44
	5)	—	—	—	—	—	—	57
$c$	min.	1	1,1	1,2	1,5	1,8	2,1	2,4
$d_a$	Types $\frac{F}{U}$	max.	5,7	6,8	9,2	11,2	15,7	17,7
			6,2	7,5	10	12,5	17,7	20,5
$d_c$	max.	11,4	13,6	17	20,8	24,7	28,6	32,8
$d_s$	max.	5,00	6,00	8,00	10,00	12,00	14,00	16,00
	min.	4,82	5,82	7,78	9,78	11,73	13,73	15,73
$d_v$	max.	5,5	6,6	8,8	10,8	12,8	14,8	17,2
$d_w$	min.	9,4	11,6	14,9	18,7	22,5	26,4	30,6
$e$	min.	7,44	8,56	10,8	14,08	16,32	19,68	22,58
$k$	max.	5,6	6,8	8,5	9,7	11,9	12,9	15,1
$k'$	min.	2,3	2,9	3,8	4,3	5,4	5,6	6,7
$l_f$	max.	1,4	1,6	2,1	2,1	2,1	2,1	3,2
$r_1$	min.	0,2	0,25	0,4	0,4	0,6	0,6	0,6
$r_2^{6)}$	max.	0,3	0,4	0,5	0,6	0,7	0,9	1
$r_3$	max.	0,25	0,26	0,36	0,45	0,54	0,63	0,72
	min.	0,10	0,11	0,16	0,20	0,24	0,28	0,32
$r_4$	ref.	4	4,4	5,7	5,7	5,7	5,7	8,8
$s$	max.	7,00	8,00	10,00	13,00	15,00	18,00	21,00
	min.	6,64	7,64	9,64	12,57	14,57	17,57	20,16
$v$	max.	0,15	0,20	0,25	0,30	0,35	0,45	0,50
	min.	0,05	0,05	0,10	0,15	0,15	0,20	0,25

Table 1 (concluded)

Dimensions in millimetres

Thread (d)			M5		M6		M8		M10		M12		(M14) <sup>1)</sup>		M16	
/ 7), 8)			l <sub>s</sub> and l <sub>g</sub> <sup>9)</sup>													
nom.	min.	max.	l <sub>s</sub> min.	l <sub>g</sub> max.	l <sub>s</sub> min.	l <sub>g</sub> max.	l <sub>s</sub> min.	l <sub>g</sub> max.	l <sub>s</sub> min.	l <sub>g</sub> max.	l <sub>s</sub> min.	l <sub>g</sub> max.	l <sub>s</sub> min.	l <sub>g</sub> max.	l <sub>s</sub> min.	l <sub>g</sub> max.
10	9,71	10,29	—	—	—	—	—	—	—	—	—	—	—	—	—	—
12	11,65	12,35	—	—	—	—	—	—	—	—	—	—	—	—	—	—
16	15,65	16,35	—	—	—	—	—	—	—	—	—	—	—	—	—	—
20	19,58	20,42	—	—	—	—	—	—	—	—	—	—	—	—	—	—
25	24,58	25,42	5	9	—	—	—	—	—	—	—	—	—	—	—	—
30	29,58	30,42	10	14	7	12	—	—	—	—	—	—	—	—	—	—
35	34,5	35,5	15	19	12	17	6,75	13	—	—	—	—	—	—	—	—
40	39,5	40,5	20	24	17	22	11,75	18	6,5	14	—	—	—	—	—	—
45	44,5	45,5	25	29	22	27	16,75	23	11,5	19	6,25	15	—	—	—	—
50	49,5	50,5	30	34	27	32	21,75	28	16,5	24	11,25	20	6	16	—	—
55	54,4	55,6	—	—	32	37	26,75	33	21,5	29	16,25	25	11	21	7	17
60	59,4	60,6	—	—	37	42	31,75	38	26,5	34	21,25	30	16	26	12	22
65	64,4	65,6	—	—	—	—	36,75	43	31,5	39	26,25	35	21	31	17	27
70	69,4	70,6	—	—	—	—	41,75	48	36,5	44	31,25	40	26	36	22	32
80	79,4	80,6	—	—	—	—	51,75	58	46,5	54	41,25	50	36	46	32	42
90	89,3	90,7	—	—	—	—	—	—	56,5	64	51,25	60	46	56	42	52
100	99,3	100,7	—	—	—	—	—	—	66,5	74	61,25	70	56	66	52	62
110	109,3	110,7	—	—	—	—	—	—	—	—	71,25	80	66	76	62	72
120	119,3	120,7	—	—	—	—	—	—	—	—	81,25	90	76	86	72	82
130	129,2	130,8	—	—	—	—	—	—	—	—	—	—	80	90	76	86
140	139,2	140,8	—	—	—	—	—	—	—	—	—	—	90	100	86	96
150	149,2	150,8	—	—	—	—	—	—	—	—	—	—	—	—	96	106
160	159,2	160,8	—	—	—	—	—	—	—	—	—	—	—	—	106	116

- 1) The size in parentheses should be avoided if possible.
- 2)  $P$  = pitch of the thread.
- 3) For lengths  $l_{nom} < 125$  mm.
- 4) For lengths  $125 \text{ mm} < l_{nom} < 200$  mm.
- 5) For lengths  $l_{nom} > 200$  mm.
- 6) Radius  $r_2$  applies both at the corners and at the flats of the hexagon.
- 7) Screws with lengths shown above the continuous thick line are threaded to head.
- 8) Reduced shank type (type R) only below the dashed thick line.
- 9)  $l_g$  is the minimum grip length.

NOTE — If the product passes the gauging in annex A, the requirements for dimensions  $e$  and  $k'$  are satisfied.

## 4 Specifications and reference standards

See table 2.

**Table 2**

Material		Steel	Stainless steel
General requirements	International Standard	ISO 8992	
	Tolerance	6g	
Thread	International Standards	ISO 261, ISO 965-2	
	Class	8.8, 9.8, 10.9	A2-70
Mechanical properties	International Standards	ISO 898-1	ISO 3506
	Product grade	A <sup>1)</sup>	
Tolerances	International Standard	ISO 4759-1	
	Finish	Black oxide (thermic or chemical)	Plain
		Requirements for electroplating are covered in ISO 4042. If different electroplating requirements are desired or if requirements are needed for other finishes, they should be negotiated between customer and supplier. Limits for surface discontinuities are covered in ISO 6157-1 and ISO 6157-3.	
Acceptability		For acceptance procedure, see ISO 3269.	
1) Dimensions <i>s</i> and <i>e</i> have tolerances to product grade B.			

## 5 Designation

Example for the designation of a hexagon flange bolt, small series, with thread M12, nominal length  $l = 80$  mm, type F or U at the option of the manufacturer, and property class 8.8:

**Hexagon flange bolt ISO 4162 - M12 × 80 - 8.8**

Example for the designation of a hexagon flange bolt, small series, with thread M12, nominal length  $l = 80$  mm, type F, and property class 8.8:

**Hexagon flange bolt ISO 4162 - M12 × 80 - F - 8.8**

If, in special cases, a hexagon flange bolt, small series, with reduced shank is required, the letter R shall be included in the designation:

**Hexagon flange bolt ISO 4162 - M12 × 80 - R - 8.8**

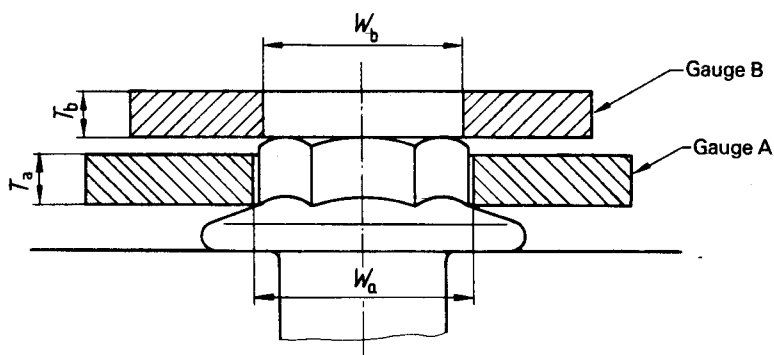
## Annex A (normative)

### Check on head and flange gauges

The head shall be gauged using two ring gauges, A and B, to demonstrate the coincidental acceptability of hexagon height, wrenching height, corner fill and width across corners.

Gauge A shall be placed over the head and shall seat on the flange.

Gauge B shall be placed on the top of the head normal to the bolt axis. The two gauges shall not be in contact.



NOTE  $W_{a \text{ min}}$  = theoretical maximum width across corners  
 $W_{b \text{ max}}$  = minimum width across corners minus 0,01 mm  
 $T_{a \text{ max}}$  = minimum wrenching height  $k'$

Figure A.1

Table A.1

Dimensions in millimetres

Thread (d)	Gauge A				Gauge B		
	$W_a$		$T_a$		$W_b$		$T_b$
	max.	min.	max.	min.	max.	min.	min.
M5	8,09	8,08	2,30	2,29	7,43	7,42	3
M6	9,25	9,24	2,90	2,89	8,55	8,54	3
M8	11,56	11,55	3,80	3,79	10,79	10,78	4
M10	15,02	15,01	4,30	4,29	14,07	14,06	4
M12	17,33	17,32	5,40	5,39	16,31	16,30	5
M14	20,79	20,78	5,60	5,59	19,67	19,66	5
M16	24,26	24,25	6,70	6,69	22,57	22,56	6

## **Annex B** **(informative)**

### **Bibliography**

- [1] ISO 4014 : 1988, *Hexagon head bolts — Product grades A and B.*
  - [2] ISO 4015 : 1979, *Hexagon head bolts — Product grade B — Reduced shank (Shank diameter  $\approx$  pitch diameter).*
  - [3] ISO 4016 : 1988, *Hexagon head bolts — Product grade C.*
  - [4] ISO 4017 : 1988, *Hexagon head screws — Product grades A and B.*
  - [5] ISO 4018 : 1988, *Hexagon head screws — Product grade C.*
  - [6] ISO 4032 : 1986, *Hexagon nuts, style 1 — Product grades A and B.*
  - [7] ISO 4033 : 1979, *Hexagon nuts, style 2 — Product grades A and B.*
  - [8] ISO 4034 : 1986, *Hexagon nuts — Product grade C.*
  - [9] ISO 4035 : 1986, *Hexagon thin nuts (chamfered) — Product grades A and B.*
  - [10] ISO 4036 : 1979, *Hexagon thin nuts — Product grade B (unchamfered).*
  - [11] ISO 4161 : 1983, *Hexagon nuts with flange — Product grade A.*
  - [12] ISO 4775 : 1984, *Hexagon nuts for high-strength structural bolting with large width across flats — Product grade B — Property classes 8 and 10.*
  - [13] ISO 7043 : 1983, *Prevailing torque type hexagon nuts with flange (with non-metallic insert).*
  - [14] ISO 7044 : 1983, *Prevailing torque type all-metal hexagon nuts with flange.*
  - [15] ISO 7411 : 1984, *Hexagon bolts for high-strength structural bolting with large width across flats (thread lengths according to ISO 888) — Product grade C — Property classes 8.8 and 10.9.*
  - [16] ISO 7412 : 1984, *Hexagon bolts for high-strength structural bolting with large width across flats (short thread length) — Product grade C — Property classes 8.8 and 10.9.*
  - [17] ISO 7413 : 1984, *Hexagon nuts for structural bolting, style 1, hot-dip galvanized (oversize tapped) — Product grades A and B — Property classes 5, 6 and 8.*
  - [18] ISO 7414 : 1984, *Hexagon nuts for structural bolting with large width across flats, style 1 — Product grade B — Property class 10.*
  - [19] ISO 7417 : 1984, *Hexagon nuts for structural bolting — Style 2, hot-dip galvanized (oversize tapped) — Product grade A — Property class 9.*
  - [20] ISO 8102 : 1990, *Hexagon flange bolts — Heavy series.*
  - [21] ISO 8673 : 1988, *Hexagon nuts, style 1, with metric fine pitch thread — Product grades A and B.*
  - [22] ISO 8674 : 1988, *Hexagon nuts, style 2, with metric fine pitch thread — Product grades A and B.*
  - [23] ISO 8675 : 1988, *Hexagon thin nuts with metric fine pitch thread — Product grades A and B.*
  - [24] ISO 8676 : 1988, *Hexagon head screws with metric fine pitch thread — Product grades A and B.*
  - [25] ISO 8765 : 1988, *Hexagon head bolts with metric fine pitch thread — Product grades A and B.*
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## **NATIONAL ANNEX A**

*( National Foreword )*

### **A-1 PACKAGING**

The packaging of hexagon flange bolts shall be in accordance with IS 1367 ( Part 18 ) : 1996 'Industrial fasteners — Threaded steel fasteners — Technical supply conditions: Part 18 Packaging ( *third revision* )'.

### **A-2 BIS CERTIFICATION MARKING**

Details available with the Bureau of Indian Standards.



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Amendments are issued to standards as the need arises on the basis of comments. Standards are also reviewed periodically; a standard along with amendments is reaffirmed when such review indicates that no changes are needed; if the review indicates that changes are needed, it is taken up for revision. Users of Indian Standards should ascertain that they are in possession of the latest amendments or edition by referring to the latest issue of 'BIS Catalogue' and 'Standards : Monthly Additions'.

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#### Amendments Issued Since Publication

Amend No.	Date of Issue	Text Affected

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